

Work Order ID 116521

116521

Page 1

April-17-14 7:47:02 AM

Item ID: D4835-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Leg Assembly, Fwd
 Start Date: 4/17/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/02/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-04-17 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4835	<u>Rev 1</u>								

110		0.00							
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110

Small Fab		0.00				<u>4</u>	<u>FF</u>	<u>NOV 26 2014</u>	
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Small Fab

Memo

ALIGN PILOT HOLES IN D4835-1 WITH PILOT HOLES IN D4869-3 AND D4920-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9957 AS PER DWG.

120	QC5- Inspect part completeness to step on W/O	0.00							
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120

QC		0.00				<u>(4)</u>			
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Quality Control

Memo

DAS
38
9-89

NOV 28 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube ☐</td> <td style="width:25%;">Crosstube ☐</td> <td style="width:25%;">Water Jet ☐</td> <td style="width:25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Revision ID: Stop ***NS2***
Item Name: Leg Assembly, Fwd
Start Date: 4/17/14 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/02/14 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Small Fab	Memo	0.00				4	FF		DEC 01 2014
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9971 A/R HYSOL BATCH: <u>H130450</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				(4)			DAS 38 9-89
Quality Control									DEC 02 2014
150	Identify as per dwg & Stock Location: <u>S+131</u>	0.00							
150									
Packaging	Memo	0.00				(4x)			DAS 46 9-89
Packaging									DEC 02 2014

contenance
recd.

P10:26707

P2L

C214/12/03

x4

~~SP~~ 4x SP15-01-7.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressuré/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

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Required Date: 5/02/14 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21 - Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-01-09

St 131 CR 15-01-08

14-12-02

15-1-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

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		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

April-17-14 7:47:05 AM

Page 1

Work Order ID: 116521

116521

Parent Item: D4835-041

D4835-041

Parent Item Name: Leg Assembly, Fwd

Start Date: 4/17/14

Required Date: 5/02/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 14-01-29 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4835-1		Manufactured	No				Each	0.0000		4			
D4835-1					121445				**	4	FF	NOV 26 2014	
Strut													
D4869-3		Manufactured	No				Each	1.0000		4			
D4869-3									**		FF	NOV 26 2014	
End Fitting, Eye													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST131 116537	1				3			
					116168	1				1			
D4920-3		Manufactured	No				Each	1.0000		4			
D4920-3									**		FF	NOV 26 2014	
End Fitting													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST 116543	1				4			
					112021	1							
HL20PB5-8		Purchased	No				Each	76.0000		16			
HL20PB5-8									**		FF	NOV 26 2014	
Rivet													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST281	66				16			
					M128110	6							
					M128579	60							
					ST284	10							
					M128429	10							

HL20PB5-8

HL20PB5-8

Rivet

HL32PB5-8

M129865

Location

Loc Qty

Loc Code

ST281

66

M128110

6

M128579

60

ST284

10

M128429

10

DQA: _____ Date: _____



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Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

April-17-14 7:47:05 AM

Page 2

Work Order ID: 116521

116521

Parent Item: D4835-041

D4835-041

Parent Item Name: Leg Assembly, Fwd

Start Date: 4/17/14

Required Date: 5/02/14

Start Qty: 4.00

Required Qty: 4.00

HL86-5

Purchased

No

Each

133.0000

16

HI 86-5

FF

NOV 28 2014

Collar

Location

Loc Qty

Loc Code

ST280

129864

33

M128110

33

ST284

100

M128228

100

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26707**

Purchase Order Date 12/3/2014

PO Print Date 12/3/2014

Page Number 2 of 6

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Total: \$8.

4	116521	D4835-041 LEG ASSEMBLY	12/5/2014	4.00	\$4.00	\$16.
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Yes

12/5/2014

LASER MARKED

SPIS-01-7

Line Total: \$16.

5	116523	D4836-041 LEG ASSEMBLY	12/5/2014	2.00	\$4.00	\$8.
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Yes

12/5/2014

LASER MARKED

Line Total: \$8.

6	121529	D4836-041 LEG ASSEMBLY	12/5/2014	2.00	\$4.00	\$8.
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Yes

12/5/2014

LASER MARKED

Note:

12/3/2014



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE Dec 22, 2014

P.O NUMBER P026707

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4802-041 LEG ASSEMBLY 2 ALL ITEMS HAVE BEEN LASER MARKED

D4804-041 BIPOP ASSEMBLY

D4834-041 LEG ASSEMBLY

D4835-041 LEG ASSEMBLY

D4836-041 LEG ASSEMBLY

D4836-041 LEG ASSEMBLY

D4866-041 LEG ASSEMBLY

D4866-042 LEG ASSEMBLY

D4866-042 LEG ASSEMBLY

D4867-041 LEG ASSEMBLY

D4878-041 LEG ASSEMBLY

D4880-041 LEG ASSEMBLY

D4881-041 LEG ASSEMBLY

D4881-042 LEG ASSEMBLY

SP15-017